

Split

Work Order ID 112996-1

112996

Page 1

Tuesday, February 11, 2014 1:38:53 PM

Item ID: PB67-43001-171

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Plate

Start Date: 2/11/2014 Start Qty: 160.00

160

Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals: Process Plan: UMF. Date: 14-2-11 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- cut as per dwg PB67-43001-171

2- deburr

162

Ø

MSP
14/02/22

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes as per dwg PB67-43001-171

162

Ø

MSP
14/02/23

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

162

Ø

MSP
14/02/23

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube ☐</td> <td style="width: 33%;">Crosstube ☐</td> <td style="width: 33%;">Water Jet ☐</td> <td style="width: 33%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Dcc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

QC8- Inspect parts - second check

0.00

125

QC

Memo

0.00

Quality Control

162 0 14-02-24

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1- countersink rivet holes as per dwg PB67-43001

2- rivet nutplate as per dwg PB67-43001-79

46x 14/03/09 36 9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
27
9-89

4/3/17

46
Can

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

Work Order ID 112996

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150

Identify as per dwg & Stock Location: Memo 0.00

150

Packaging

Memo

0.00

Packaging

460x

14-3-7

DAS
28
9-89

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

MLJ

14-03-13

AA 14-03-10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 1

Tuesday, February 11, 2014 1:38:52 PM

Work Order ID: 112996

Parent Item: PB67-43001-171

Parent Item Name: Mounting Plate

Start Date: 2/11/2014

Required Date: 2/28/2014

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6A1.000W.125

6061T6 ANGLE 1.00 x 1.00 x .125W

Purchased

No

100

f

0.2000

0.0833

15

Location

Loc Qty

Loc Code

MAT006

0.2

125006

0.2

MS20426AD3-4

RIVET

Purchased

No

130

Each

10,337.000

2

320

Location

Loc Qty

Loc Code

ST334

4000

m127432 -

4000

ST509

6337

125578 -

6337

MS21075L3

Nut Plate

MS21075L3N

Purchased

No

130

Each

0.0000

1

160

4D M128257 46x

M128265

17,833'

14/02/22

DAS
36
9-89

DAS
36
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General
☐ Bending	☐ Bend
☐ Centre Not Concentric to O/S	☐ BOM/Route
☐ Cracks	☐ Broken/Damaged
☐ Crushed/Crimped	☐ Burrs
☐ Cuffs	☐ Contamination
☐ Heat Treat	☐ Countersink
☐ Inspection Strip in Tube	☐ Cut Too Short
☐ Ripples in Bend	☐ Drill Holes
☐ Torque Waves in Extrusion	☐ Drawing
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☐ Wave/Twist in Tube	☐ Folio
	☐ Grain
	☐ Hardware
	☐ Inspection Incomplete
	☐ Instructions Incomplete/Unclear
	☐ Maintenance
	☐ Mislabelled
	☐ Misread
	☐ Offset
	☐ Out of Calibration
	☐ Out of Sequence
	☐ Outside Dimensions
	☐ Ovalized
	☐ Over/Under tolerance
	☐ Part Incorrect
	☐ Part Lost/Missing
	☐ Part Moved
	☐ Positioned Wrong
	☐ Power Loss/Surge
	☐ Pressure/Forced
	☐ Temperature/Cure
	☐ Weld
	☐ Wrong Stock Pulled
	☐ Other

8

7

6

5

4

3

2

1

D

C

B

A

D

C

B

A

0.13
REFRADIUS
OPTIONAL1.00
TYP. REF
 $\triangle C$ $\phi 0.098$ THRU
 $\phi 0.167 \times 100^\circ$ CSK
 2PL

 $\triangle C$

0.500

 $\triangle C$

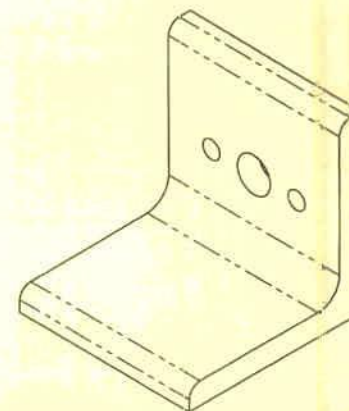
0.250

 $\phi 0.194$
THRU

0.500

0.500

1.00

**B67-43001-171 MOUNTING PLATE**

#1129916

RELEASED
 2009-08-24
 MD
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6510/T6511) ALUMINUM ANGLE
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A1.00XW125
- 1) MATEROR: D6207-001
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 27 OF PREMIER AVIATION DRAWING No. B67-43001; ADDED CSKED Ø0.098 THRU HOLES. REASON: SEE PAR09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	ASS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-171	SHEET 1 OF 1	
APPROVED	MB	TITLE	SCALE	
DE APPR.	N/A	MOUNTING PLATE	NTS	
DATE	09.02.19	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8

7

6

5

4

3

2

1

NCR: Yes / No

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